

Date: Wednesday, 3/8/2006 1:09:41 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 26161		
Estimate Number	: 11375		
P.O. Number	: N/A	Part Number	: D33871
This Issue	: 3/8/2006 S.O. No. N/A	Drawing Number	: D3387 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25933	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 4/5/2006 Qty: 8 Um: Each
Checked & Approved By	: <u>SA 06.03.08</u>		
Comment	: Est:A 05.06.10 New Issue KJJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5685 f(s)/Unit Total: 12.5479 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6/T651 (QQ-A-200/8)
 (M6061T6B0.500x06.000)
 Identify for D3387-1
 Batch: M100285

12.5479

SA 06.03.21

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 6.000" x 0.500" x 17.800" long

SA 06.03.21

8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA511 and Dwg D3387 ✓ SA
 Identify as D3387-1
 C'sink Ø0.375" as per Dwg D3387 (Manual)
 Tumble and Deburr NO sharp edges

SA 06.03.22

8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.03.22

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 26/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 1:09:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 26161

Part Number: D33871

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/03/24

8

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WPA20*

PE. 06-03-24

8

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

9 06/03/24 (8)

Job Completion



U 06-03-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26161
Description: Arm		Part Number:	D3387-1
Inspection Dwg: D3387 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	+/-0.010	R.125	/			
0.135	+0.020/-0.000					Not on drawing
Ø0.375 x100°	+/-0.010	378x100°	/			Manual
R0.032	+/-0.010	R.032	/			
0.500	+/-0.010	.500	/			
0.500	+/-0.010	.501	/			
7.577	+/-0.010	7.575	/			
R0.125	+/-0.010	R.125	/			
Ø0.507	+0.000/-0.001	Ø.506	/			
0.250	+/-0.010	.249	/			
1.347	+/-0.010	1.348	/			
2.000	+/-0.010	2.001	/			
1.000	+/-0.010	.9995	/			
Ø0.191	+0.005/-0.000	Ø.192	/			
R0.300	+/-0.010	R.300	/			
2.033	+/-0.010	2.034	/			
0.280	+/-0.010					Not on drawing
0.222	+/-0.010					Not on drawing
1.700	+/-0.010	1.704	/			

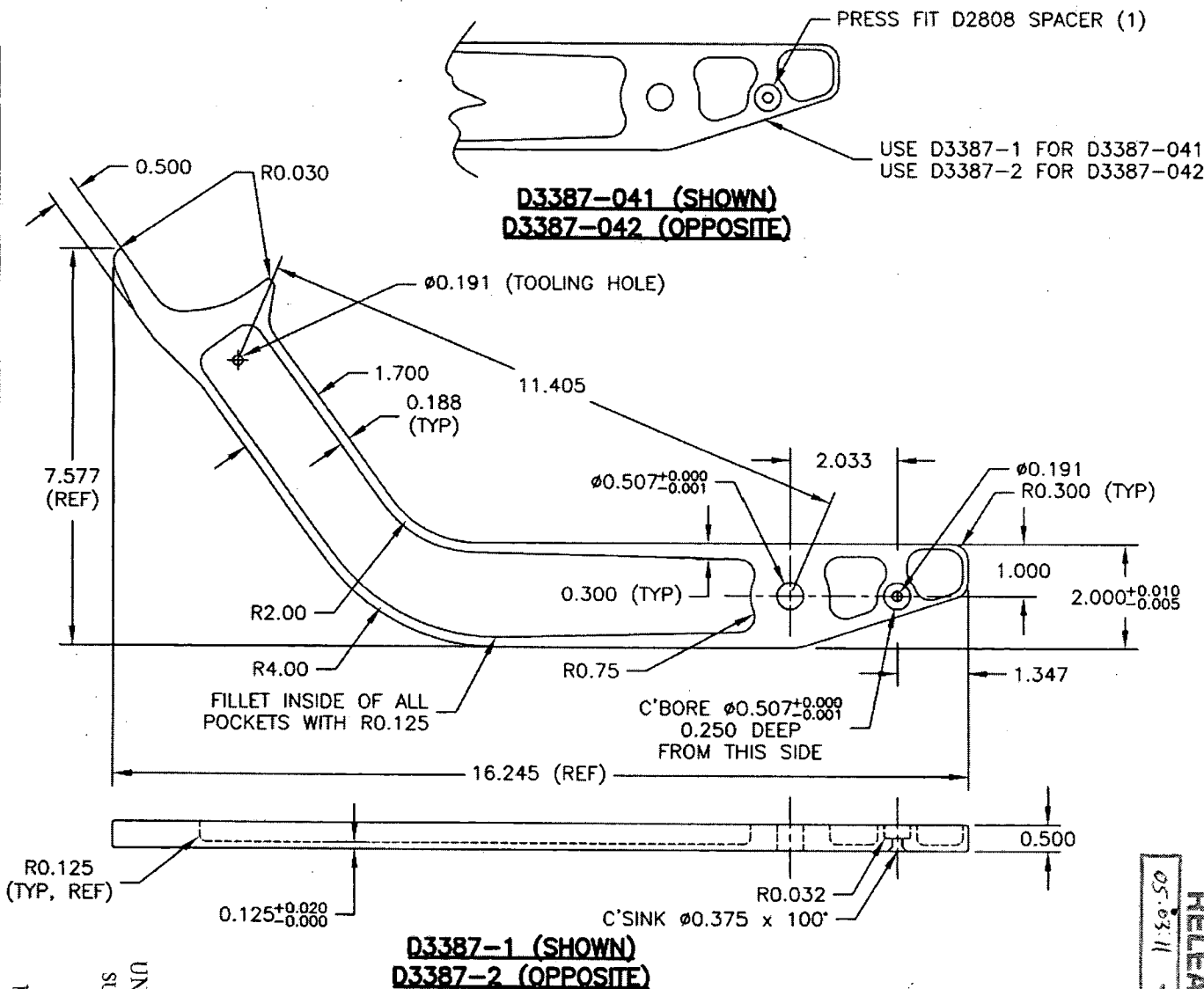
Measured by:	SD	Audited by:	BC	Prototype Approval:	N/A
Date:	06.03.22	Date:	06.03.22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3387	REV. A
DATE 05.01.18	TITLE ARM	SHEET 1 OF 1	SCALE 1:3
A	05.01.18	NEW ISSUE	

RELEASED
05.03.11



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

- 1) MACHINE PER DRAWING FILE "D3387-A.DWG"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK
(REF DART SPEC. M6061T6B0.500)
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 26161